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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	PREVIOUS PROTOTYPE REVISION PR19		
N/C	INITIAL DRAWING RELEASE	06-14-21	P. BRAVO
A	INCORPORATED ECN 06962	03-24-22	J.GARDINER

NOTES:

- 1 IDENTIFY IAW MPP-120
- 2 MATERIAL: 3K 2X2 TWILL CARBON FIBER PREPREG, AXIOM AX-5112T
- 3 MATERIAL: #120 E-GLASS EPOXY PREPREG WITH 48% RC
4. MANUFACTURE IAW MPP-145
- 5 PRIME PARTS WITH TWO COATS IAW MIL-PRF-85582C, TYPE 1, CLASS N
6. INSPECT DIAMETERS ON ALL HOLES
- 7 PART GEOMETRY AND HOLE LOCATION DIMENSIONS CONTROLLED BY CAD MODEL.
FORMAT FILE NAME AS:
"652.26XX(PART NUMBER) XXX(REVISION LEVEL) XXXXXXXXXXXX (PART DESCRIPTION) XX-XX-XX(DATE)"
8. INSPECT IAW DA169ATP-4.
- 9 LAYER THICKNESS TO TRANSITION OVER 1.00-1.50 IN
- 10 CURED AT 250°F WITH RAMP RATE OF 1-3 DEGREES PER MINUTE, HOLD AT 250°F FOR 60 MINUTES
- 11 ZERO DEGREE WARP DIRECTION LISTED ON CORRESPONDING PART DRAWINGS
- 12 DELETED
- 13 MATERIAL: AR 4315HP ADHESIVE, RESINLAB L.L.C
- 14 INSTALL DOUBLER F/N 5-10 USING ADHESIVE F/N 11 CONCENTRIC TO FLANGE HOLES IN F/N 1 OR 2 AND .200" HOLES MATCH PUNCHED AND DRILLED PRIOR TO PRIMER DELTA 5.
- 15 MAX WEIGHT: 6.86 LBS.
- 16 MAX WEIGHT: 2.95 LBS.
- 17 APPLY PLY G1 ONLY WHERE SHOWN
- 18 APPLY PLY G2 ONLY WHERE SHOWN
- 19 APPLY MINIMUM 2.00 X 2.00 SQUARES AROUND HOLE LOCATIONS SHOWN. 2.00 WIDE STRIPS ALLOWED TO STRETCH BETWEEN HOLES THAT ARE LESS THEN 3.00 APART.
- 20 APPLY MINIMUM 3.00 X 3.00 SQUARES AROUND HOLE LOCATIONS SHOWN.

A/R	A/R	11	600.1005	ADHESIVE	13	
1		10	654.7025	RIGHT HAND 3RD DOUBLER (FWD)		
	1	9	654.7024	LEFT HAND 3RD DOUBLER (FWD)		
1		8	654.7023	RIGHT HAND 2ND DOUBLER (FWD)		
	1	7	654.7022	LEFT HAND 2ND DOUBLER (FWD)		
1		6	654.7021	RIGHT HAND 1ST DOUBLER (FWD)		
	1	5	654.7020	LEFT HAND 1ST DOUBLER (FWD)		
		4	652.2613	FWD COVER LH	2	5 7 16
		3	652.2612	FWD COVER RH	2	5 7 16
	1	2	652.2611	FWD POD LH	2 3	5 7
1		1	652.2610	FWD POD RH	2 3	5 7
X			652.2602	FWD POD ASSY RH		15
	X		652.2601	FWD POD ASSY LH		15
2602	2601	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.

QTY		PARTS LIST			
NEXT ASSY (S)	652.2400	ORIGINAL DATE (MO-DA-YR)	05-26-18		
		DRAWN BY E.ANDERSSON	CHECKER P.BRAVO		
		DRAWING APPROVAL P.BRAVO 06-14-21			
		CONTRACT No.			
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ± .5°			
		SIZE B	CAGE CODE 07MZ6	DWG. NO. 652.2600	REV. A
		SCALE NONE			SHEET 1 OF 11

DART
AEROSPACE

APICAL INDUSTRIES, INC.
dba DART AEROSPACE

3030 ENTERPRISE CT.,
SUITE A
VISTA, CA. 92081
(760)-724-5300

AW169 FWD POD AND COVER

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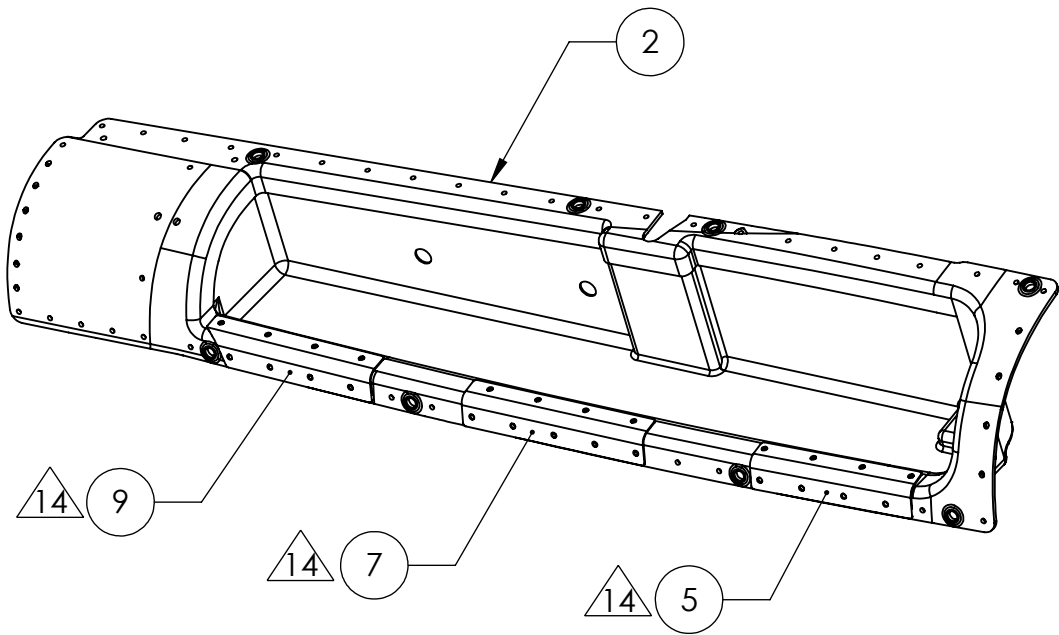
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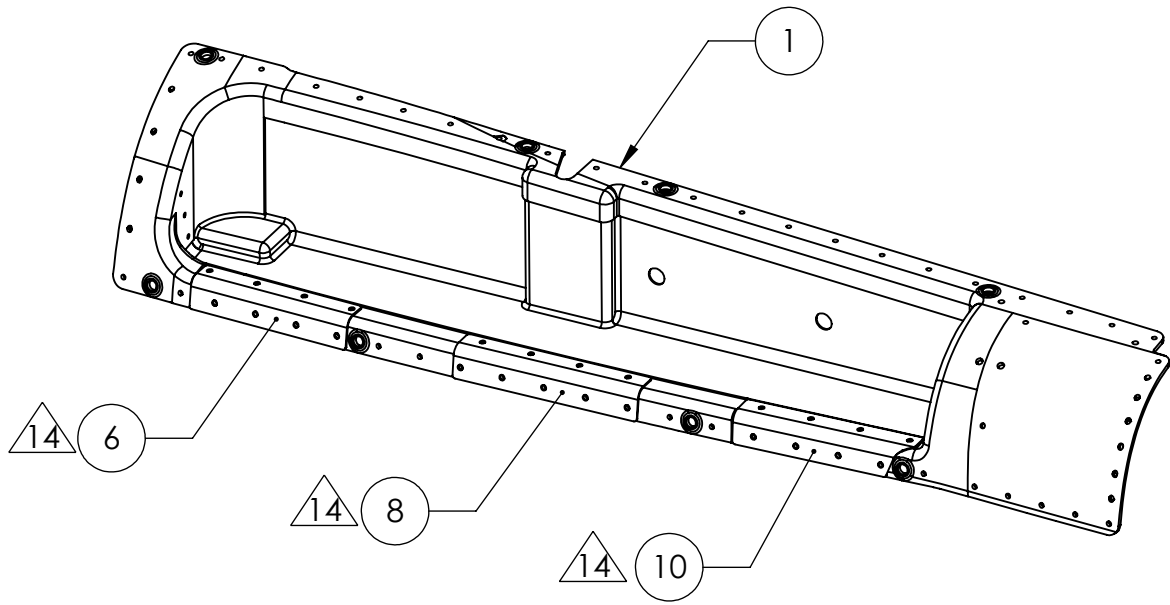
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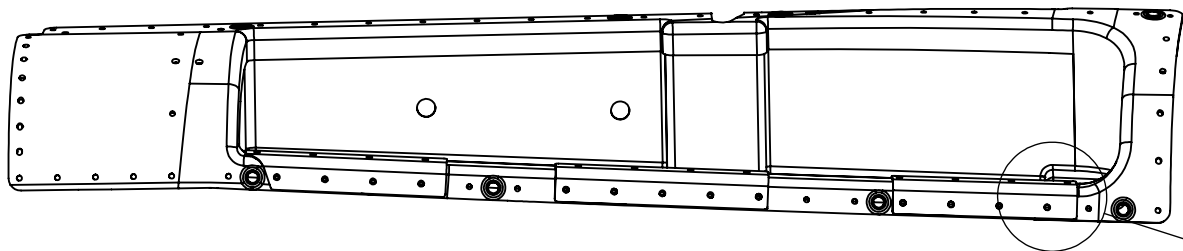
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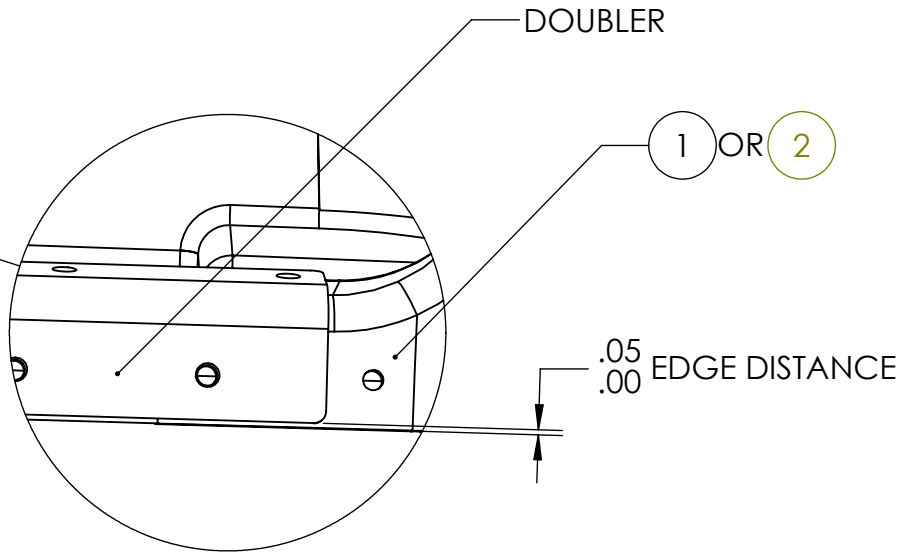
652.2601




652.2602



652.2601 SHOWN
652.2602 OPPOSITE



TYPICAL DOUBLER INSTALLATION

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		SCALE NONE		SHEET 2 OF 11	

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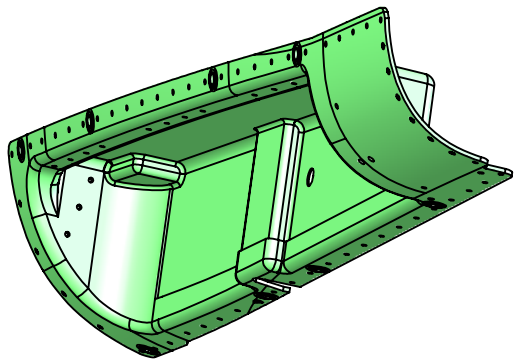
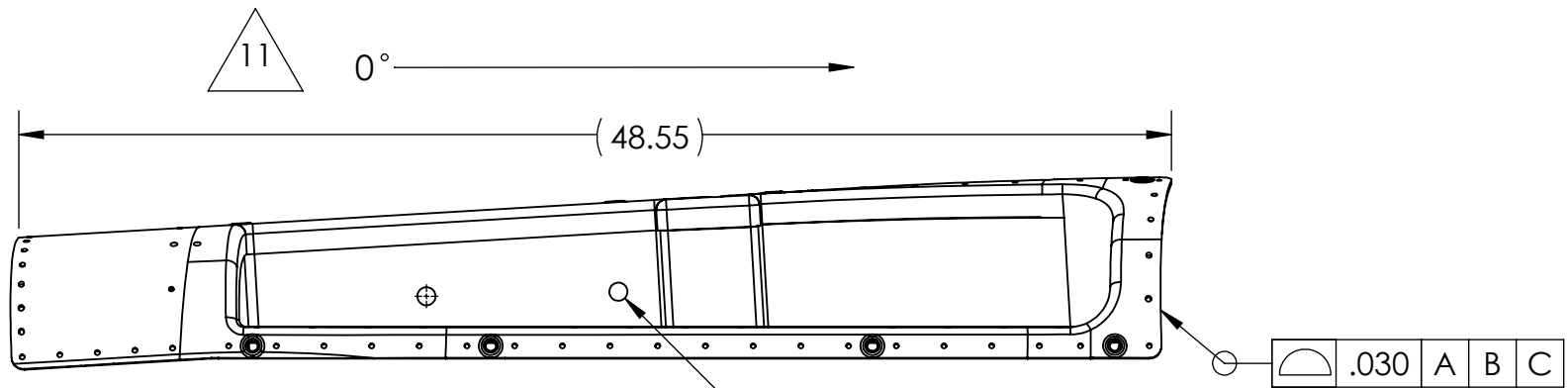
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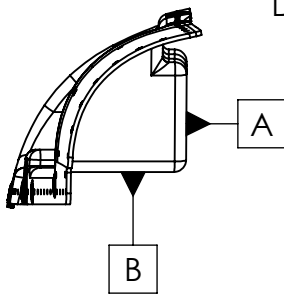
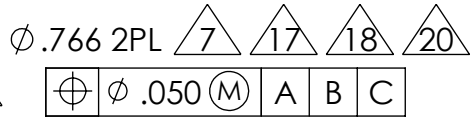
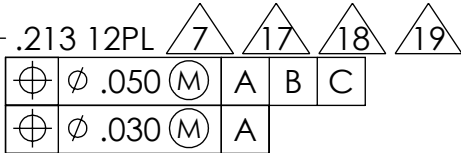
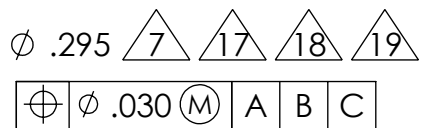
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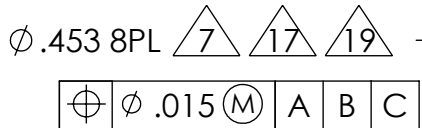
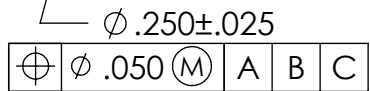
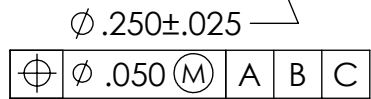
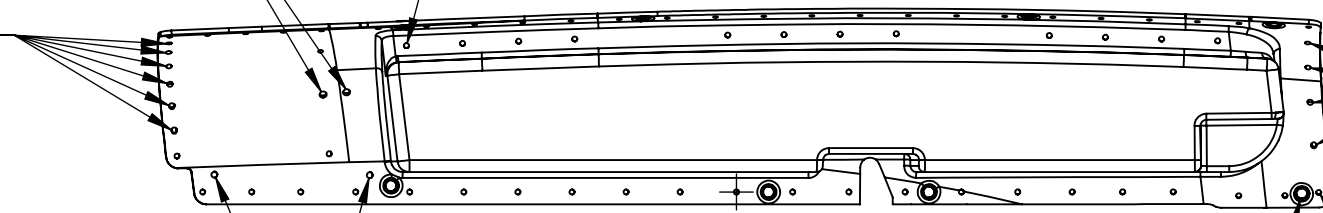
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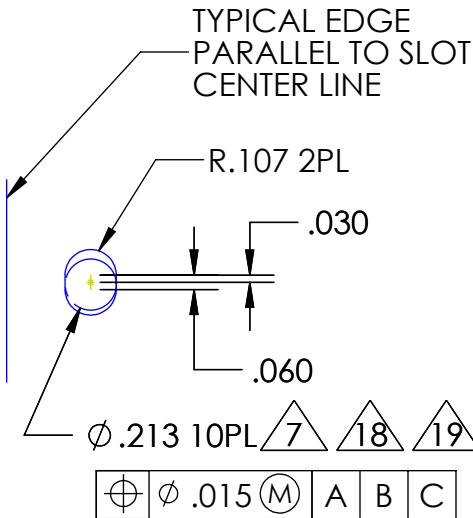
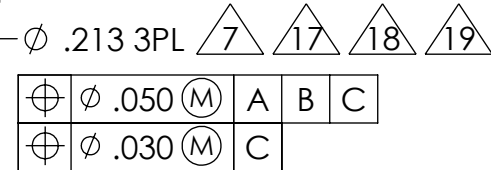
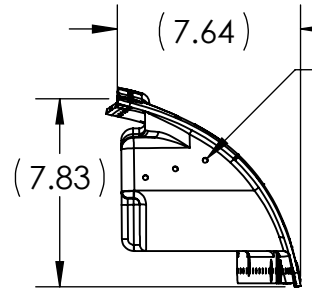
652.2611
652.2610 OPPOSITE



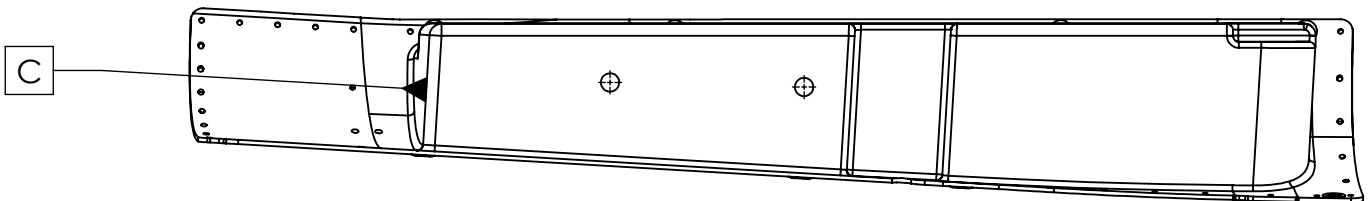
DETAIL Q
6 PL



DETAIL Q
4 PL




DETAIL Q
SLOTTED HOLE



652.2611
652.2610 OPPOSITE

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DRAWN BY E.ANDERSSON	CHECKER P.BRAVO	APICAL INDUSTRIES, INC. dba DART AEROSPACE			
DRAWING APPROVAL P.BRAVO 06-14-21					
CONTRACT No.		AW169 FWD POD AND COVER			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		SIZE B	CAGE CODE 07MZ6	DWG. NO. 652.2600	REV. A
		SCALE NONE			
		SHEET 3 OF 11			

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LAMINATE 1 (.180)

LAMINATE 2(.070)

LAMINATE 1 (.180)

652.2611, 652.2610 OPPOSITE
LAYER MAP AFT END



LAMINATE 2(.070)

LAMINATE 1 (.180)

652.2611, 652.2610 OPPOSITE
LAYER MAP FWD END



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DRAWING APPROVAL P.BRAVO 06-14-21	
CONTRACT No.	

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ARE:
2 PLACE DECIMALS $\pm .01$
3 PLACE DECIMALS $\pm .005$
ANGLES $\pm .5^\circ$



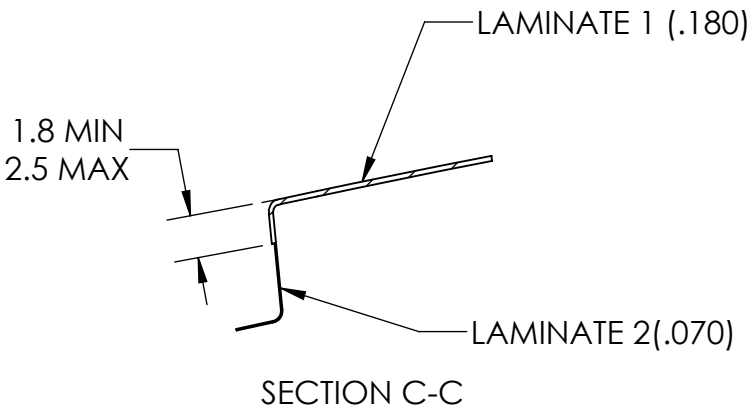
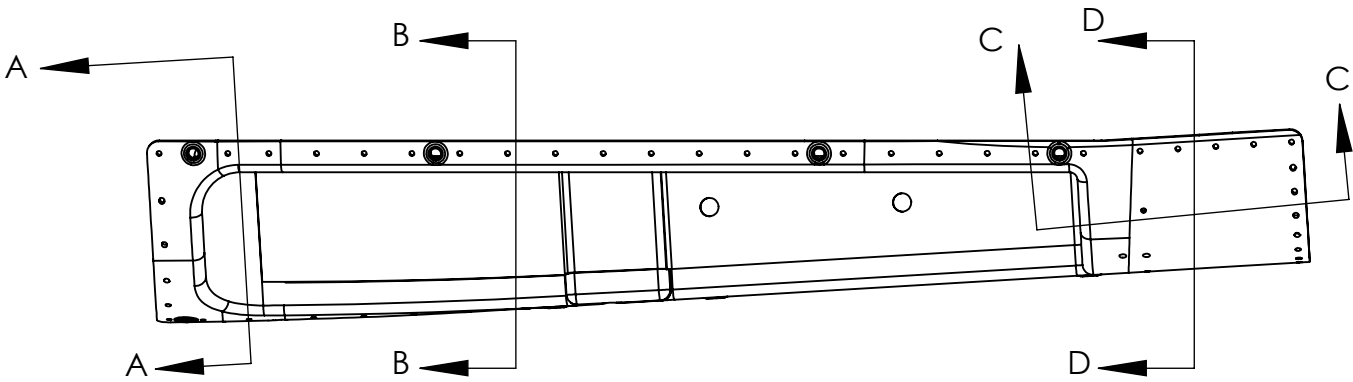
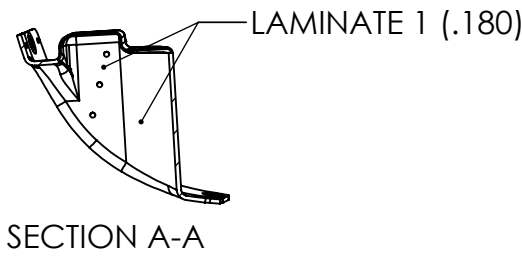
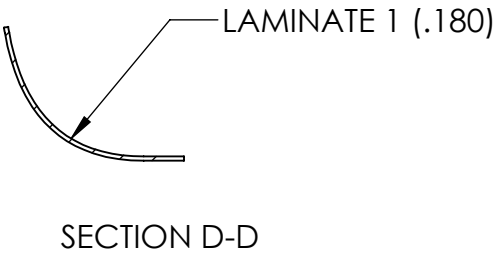
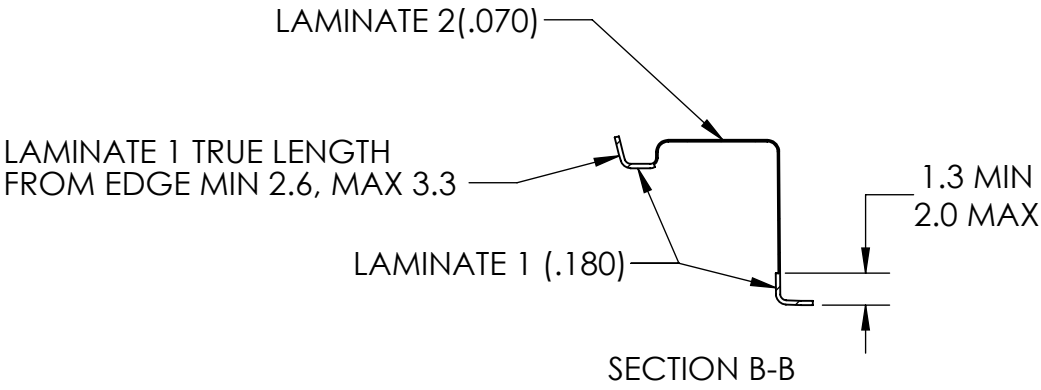
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AW169 FWD POD AND COVER


SIZE B	CAGE CODE 07MZ6	DWG. NO. 652.2600	REV. A
SCALE NONE	SHEET 4 OF 11		

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652.2611, 652.2610 OPPOSITE
LAYER CROSS SECTIONS

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		CAGE CODE 07MZ6	DWG. NO. 652.2600
		SCALE NONE	SHEET 5 OF 11

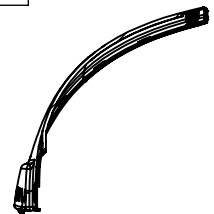
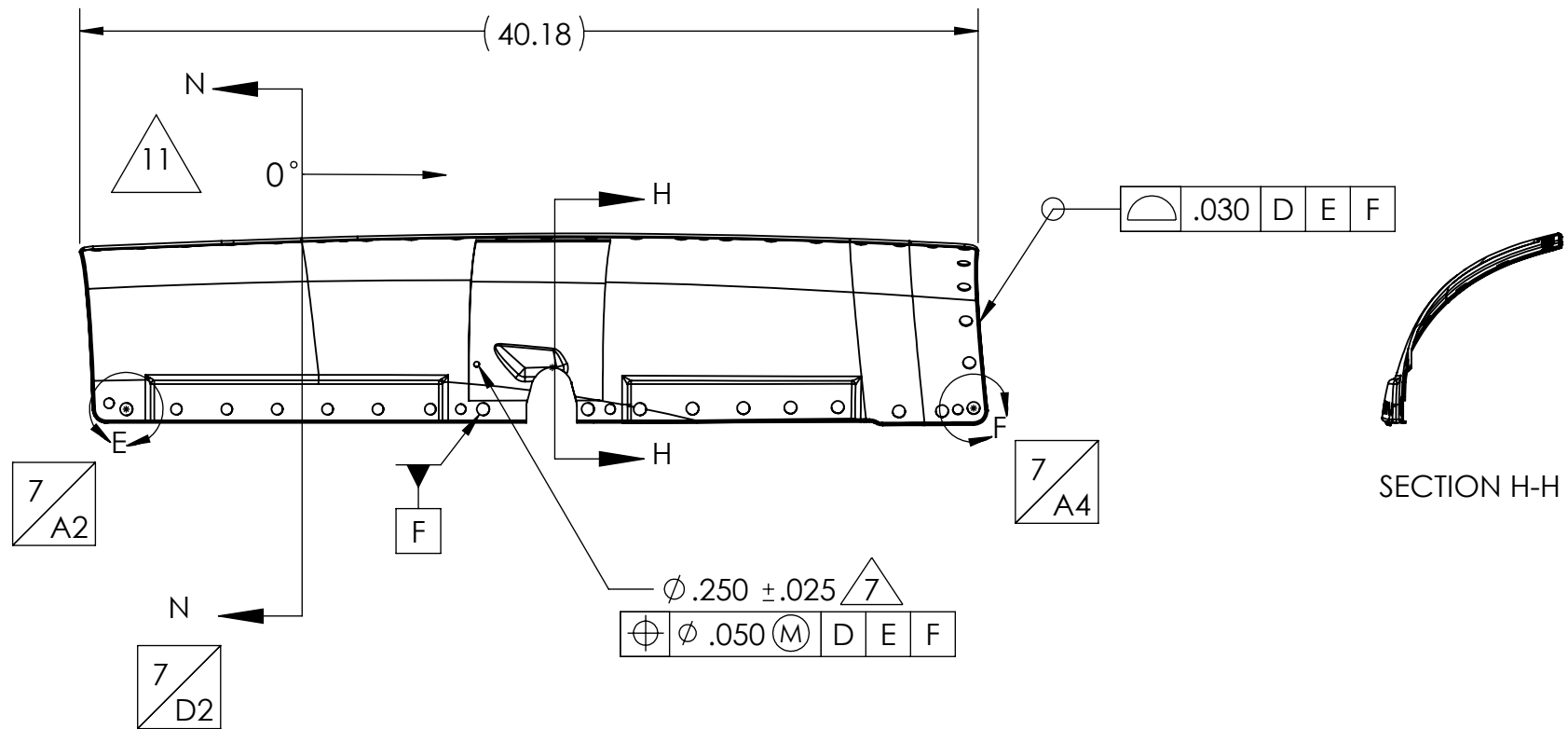
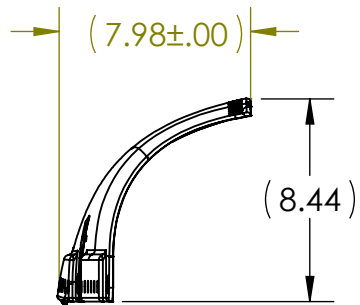
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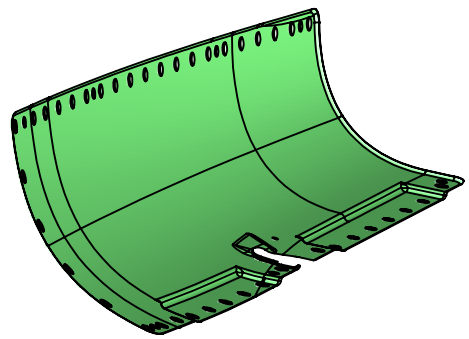
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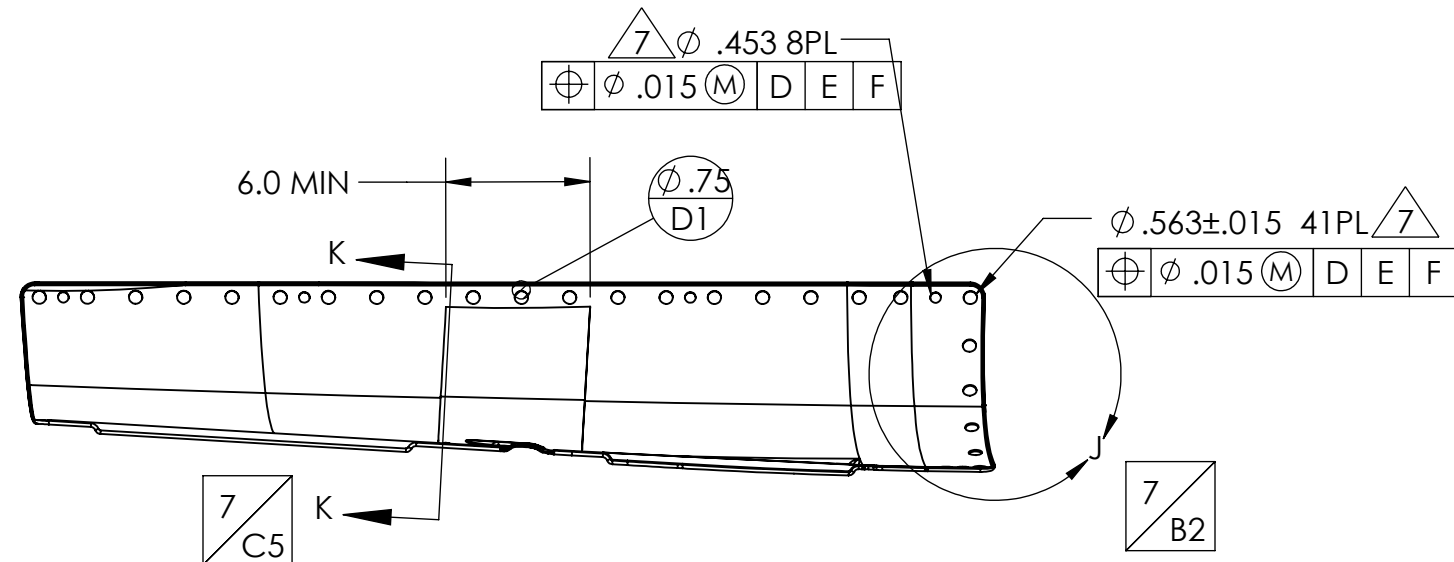
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SECTION H-H



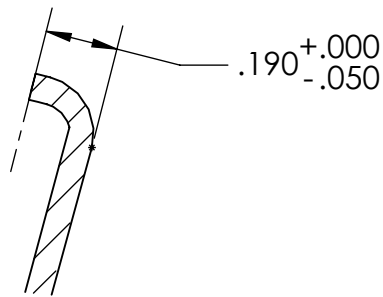
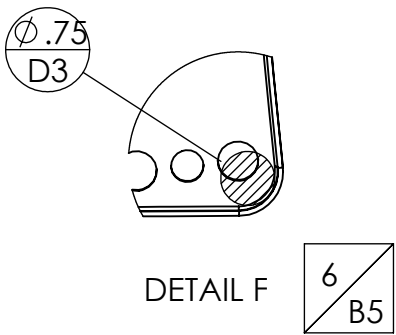
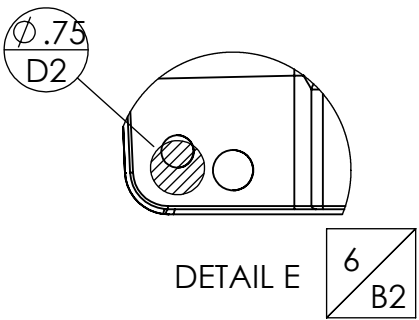
652.2613
652.2612 OPPOSITE



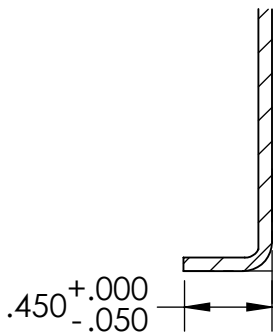
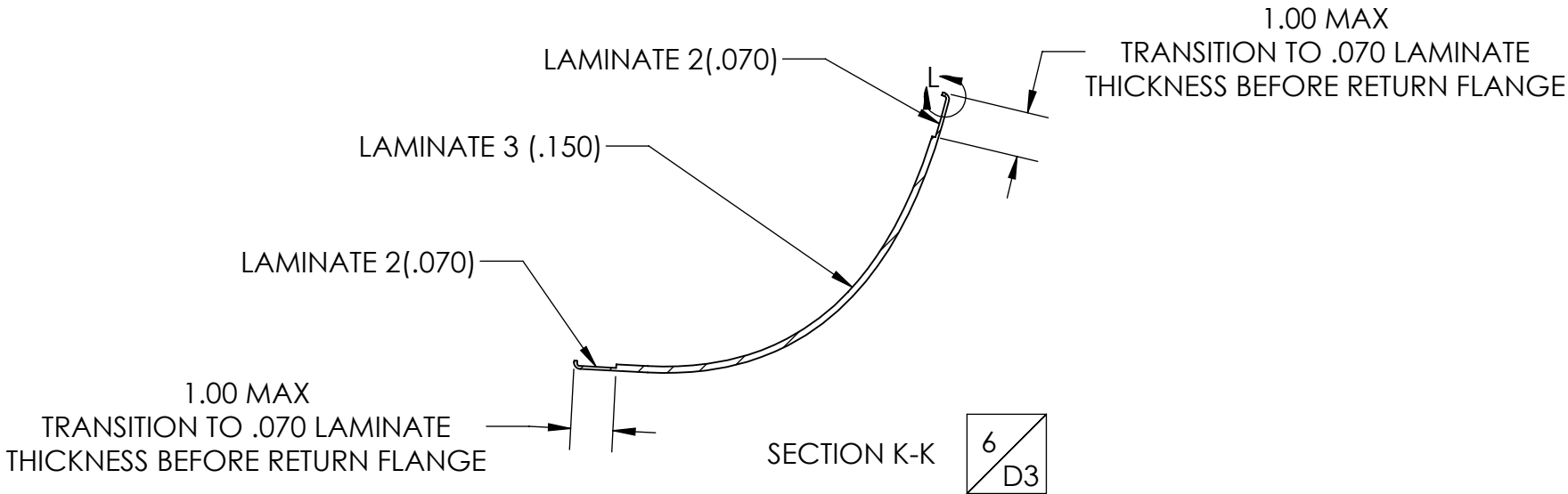
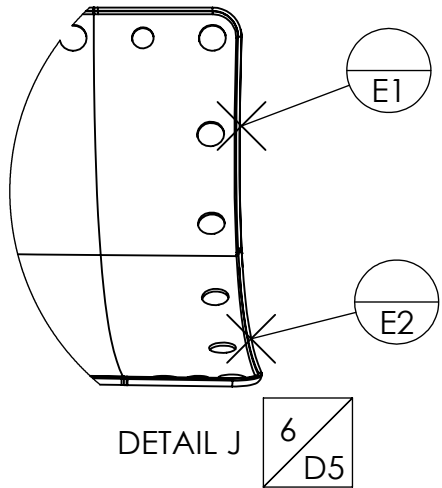
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652.2612 OPPOSITE

ORIGINAL DATE (YR-MO-DA) 05-26-18		DART 3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300	
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		DWG. NO. 652.2600	
		SCALE NONE	SHEET 6 OF 11

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TYPICAL COVER RETURN FLANGE
LENGTH UNLESS NOTED



DETAIL RETURN FLANGE
AT INDENT 2 PL

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CAGE CODE 07MZ6		DWG. NO. 652.2600	SHEET 7 OF 11
SCALE NONE			

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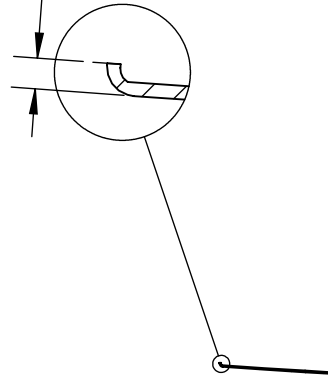
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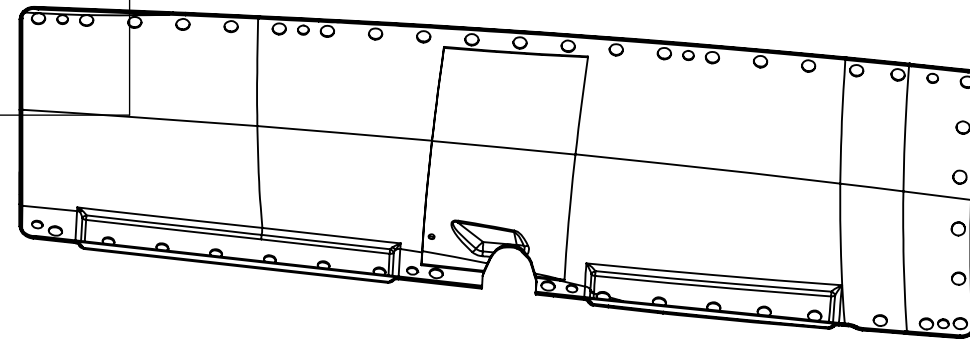
.16^{+.00}
-.05



SECTION P-P

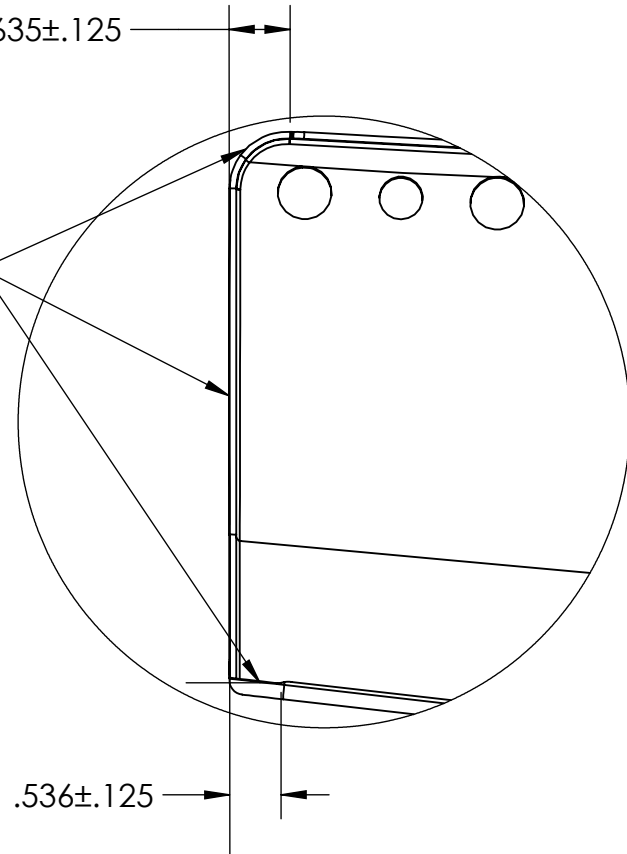
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P

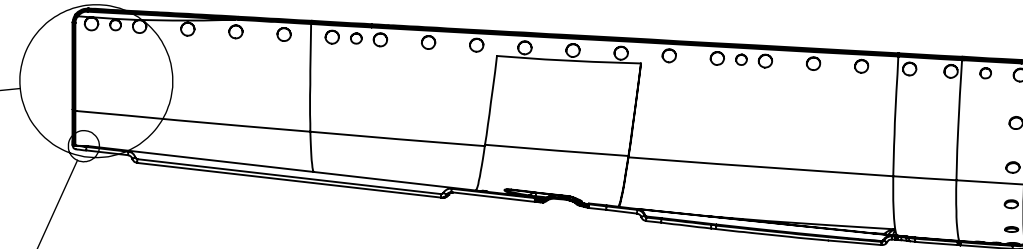


.635±.125

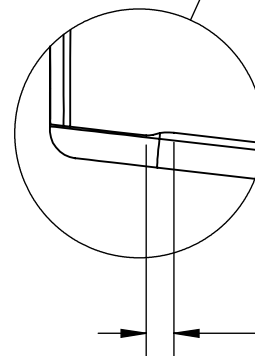
TRIM AREA



.536±.125



652.2613
652.2612 OPPOSITE
AFT END RETURN FLANGE TRIM



.125-.250 TRANSITION FROM .19 TO .16
RETURN FLANGE
2PL

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ANGLES ± .5°

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SIZE B	CAGE CODE 07MZ6	DWG. NO. 652.2600	REV. A
SCALE NONE	SHEET 8 OF 11		

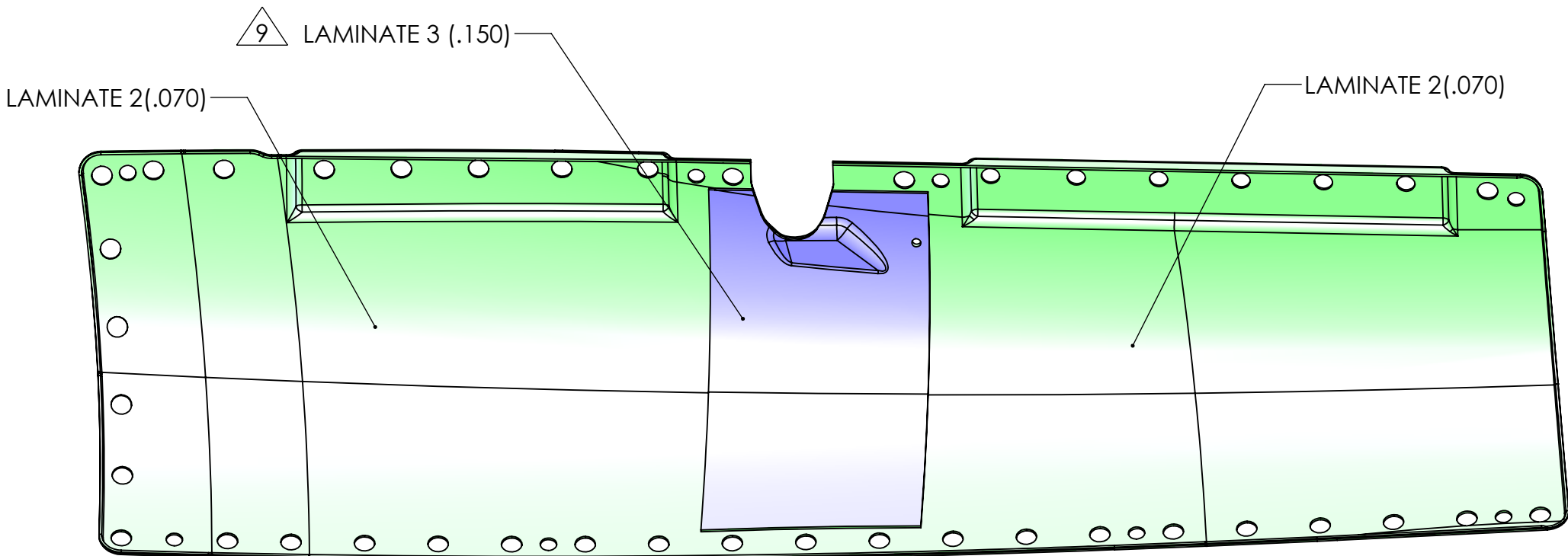
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CONCAVE SIDE OF 652.2613 SHOWN, 652.2612 OPPOSITE
LAYER MAP

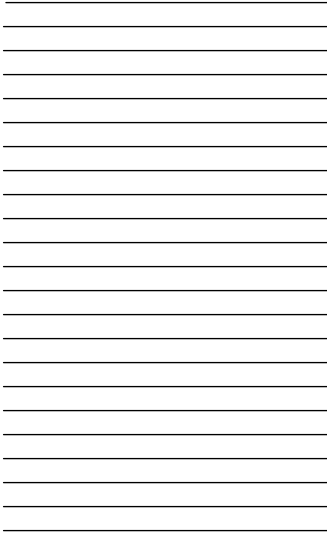
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CONTRACT NO.		SIZE B		CAGE CODE 07MZ6	DWG. NO. 652.2600	REV. A
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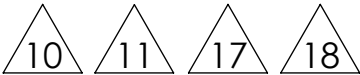
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TOOLING SIDE

G1
P01



LAYUP OF PREPREG LAYERS
.180^{+.050}_{-.010} THICKNESS

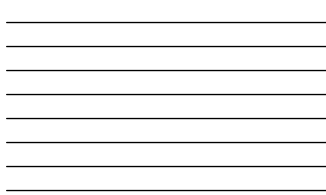


LAMINATE 1 - .180in ^{+.050} _{-.010} OVERALL THICKNESS			
PLY	WARP ANGLE	MATERIAL	THICKNESS
G1	N/A	3	.008-.010
P01	0	2	.008-.010
P02	+45	2	.008-.010
P03	-45	2	.008-.010
P04	90	2	.008-.010
P05	+45	2	.008-.010
P06	-45	2	.008-.010
P07	0	2	.008-.010
P08	+45	2	.008-.010
P09	-45	2	.008-.010
P10	90	2	.008-.010
P11	0	2	.008-.010
P12	90	2	.008-.010
P13	-45	2	.008-.010
P14	+45	2	.008-.010
P15	0	2	.008-.010
P16	-45	2	.008-.010
P17	+45	2	.008-.010
P18	90	2	.008-.010
P19	-45	2	.008-.010
P20	+45	2	.008-.010
P21	0	2	.008-.010
G2	N/A	3	.008-.010



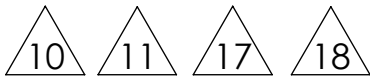
TOOLING SIDE

G1
P01



P21
G2

LAYUP OF PREPREG LAYERS
0.070^{+.030}_{-.015} THICKNESS



LAMINATE 2 - .07in ^{+.030} _{-.015} OVERALL THICKNESS			
MATERIAL	PLY	WARP ANGLE	THICKNESS
3	G1	N/A	.008-.010
2	P01	0	.008-.010
2	P02	+45	.008-.010
2	P03	-45	.008-.010
2	P04	90	.008-.010
2	P05	-45	.008-.010
2	P06	+45	.008-.010
2	P07	0	.008-.010
3	G2	N/A	.008-.010



ORIGINAL DATE
(YR-MO-DA) 05-26-18
DRAWN BY E.ANDERSSON
CHECKER P.BRAVO
DRAWING APPROVAL
P.BRAVO
06-14-21
CONTRACT No.

DART 3030 ENTERPRISE CT.,
AEROSPACE SUITE A
APICAL INDUSTRIES, INC. VISTA, CA. 92081
dba DART AEROSPACE (760)-724-5300

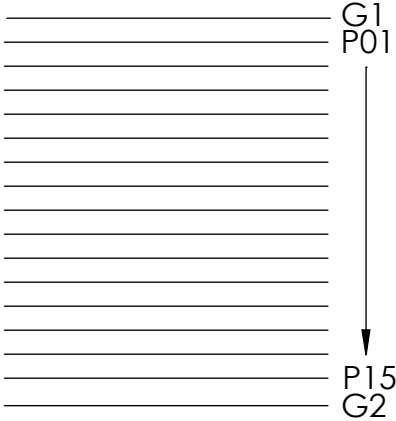
AW169 FWD POD AND COVER

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ARE:
2 PLACE DECIMALS ±.01
3 PLACE DECIMALS ±.005
ANGLES ±.5°

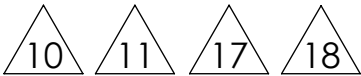
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B	07MZ6	652.2600	A
SCALE NONE		SHEET	10 OF 11


















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TOOLING SIDE




LAYUP OF PREPREG LAYERS
.150 ^{+0.030}/_{-.030} THICKNESS



LAMINATE 3 - .150in ^{+0.030} / _{-.030} OVERALL THICKNESS			
PLY	WARP ANGLE	MATERIAL	THICKNESS
G1	N/A		.008-.010
P01	0		.008-.010
P02	+45		.008-.010
P03	-45		.008-.010
P04	90		.008-.010
P05	+45		.008-.010
P06	-45		.008-.010
P07	0		.008-.010
P08	90		.008-.010
P09	0		.008-.010
P10	-45		.008-.010
P11	+45		.008-.010
P12	90		.008-.010
P13	-45		.008-.010
P14	+45		.008-.010
P15	0		.008-.010
G2	N/A		.008-.010



ORIGINAL DATE (YR-MO-DA) 05-26-18		 3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300			
DRAWN BY E.ANDERSSON				CHECKER P.BRAVO	
DRAWING APPROVAL P.BRAVO 06-14-21				CONTRACT No.	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ± .5°		SIZE B	CAGE CODE 07MZ6	DWG. NO. 652.2600	REV. A
SCALE NONE				SHEET 11 OF 11	